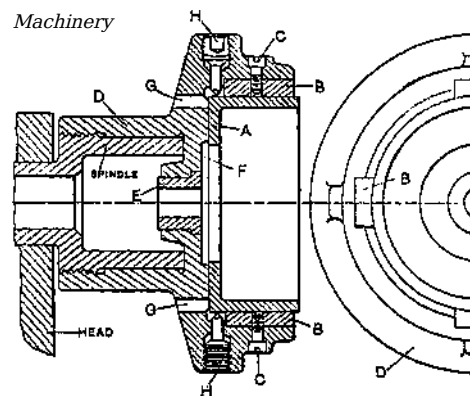


end 5 so that it enters the angular slots *S* and *T* of the index ring. Clearance is allowed between the end of the bolt and the bottom of these slots so that wear is automatically taken care of. A stud *O* is screwed into the under side of the index bolt and a stiff coiled spring at *N* keeps the bolt firmly in position. The pin *U* is obviously used for drawing the bolt back and indexing the fixture. Points worthy of note in the construction of this fixture are the liner bushing at *E*, the steel locating ring *Lj* and the automatic method of taking up wear by the angular lock bolt *M*.

Fixture with Inserted Jaws. — The work shown at *A* in Fig. 4 is a steel casting which has to be finished on the inside.



**Fig. 4. Fixture**  
provide  
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angeabl  
e Jaws  
for  
Holding  
Differe  
nt Sizes  
of Work

These castings are made in

two sizes, one of which is 1 inch larger than the other. It was desired to use the same fixture for both pieces in order to avoid the expense of making two fixtures. (The larger piece of work is shown in the illustration.) For this purpose a fixture *D* was designed to be screwed to the end of the lathe spindle in the usual manner. There are four jaws *B* which rest in slots around the inside of the fixture, these jaws being drawn back into their seats by the screws *C* in order to be ground in place to the correct diameter. Beyond the ends of the jaws, the pointed hollow set-screws // are so placed that they will come opposite to the web portion of the casting.